



Dart Aerospace Ltd.
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Tel (613) 632-5200

601.3902
Job Sheet 169374



Part No: 601.3902

Job Qty: 20 ea

Part Name: Eye Bolt



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/8/17

Job Tracking No:

Due Date: 1/12/18

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV N/C IPP REV:A NEW ISSUE 16-03-07 JLM VERIFIED BY:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea		1/11/18	0.00	0.00	Start Up Machining-1		JK 17-12-21
100	Doosan	20 pcs		1/12/18	0.56	11.27	Doosan		JK
110	QC	20 pcs		1/12/18	0.00	0.00	QC2 Machining-1		JK
120	QC	20 pcs		1/12/18	0.00	0.00	QC8 Machining-1		JK 17-12-21
130	Packaging	20 pcs		1/12/18	0.00	0.00	Packaging3-1		AT
140	QC21-SA	20 Ea		1/12/18	0.00	0.00	QC21		

Part Op 100 - 1-Turn as per Folio FB466 Dwg 601.3902 Folio Rev: ____ Dwg Rev: ____ 2-Deburr
Descriptions: 140 - Identify as MPP-120

DEC 22 2017

CLK100

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M316R1.000	3	7	0	0
	FM135061	2.63			

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Eye Bolt	0.310Inches ± 0.010	0.320 0.300	Radius	
2	Eye Bolt	0.620Inches ± 0.010	0.630 0.610		
3	Eye Bolt	0.470Inches ± 0.010	0.480 0.460		
4	Eye Bolt	0.400Inches ± 0.010	0.410 0.390		
5	Eye Bolt	0.220Inches ± 0.010	0.230 0.210		
6	Eye Bolt	0.150Inches ± 0.010	0.160 0.140		
7	Eye Bolt	1.310Inches ± 0.010	1.320 1.300		
8	Eye Bolt	0.250Inches + 0.005 - 0.001	0.255 0.249	Diameter	
9	Eye Bolt	1.270Inches ± 0.010	1.280 1.260		
10	Eye Bolt	0.830Inches ± 0.010	0.840		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

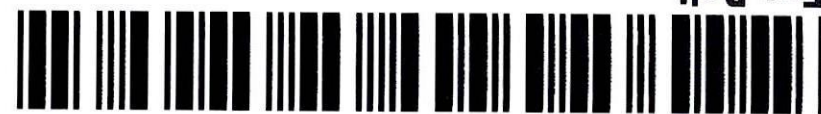
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS			
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Date : _____	Step #: _____	QTY Effective : _____			MRB (QSI042) Approval
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor Approval Verification

Job No: 169374
Mtg Date: 12/21/17

Change No: _____
Operation: _____
Revision: _____
PART NO: 601.3902
Start up Operation

Root Cause		
Environment ☐	No Re-verification ☐	Pressure/Forced ☐
Design ☐	Operator ☐	Bending ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐
Material ☐	Use for Testing ☐	Cuffs ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐
Past Expiry Date ☐	Manufacturing Process ☐	
Misidentified ☐	Past Due ☐	OTHER : _____



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			0.820
11	Eye Bolt	0.730Inches $\pm$ 0.010	0.740 0.720
12	Eye Bolt	0.530Inches $\pm$ 0.010	0.540 0.520
13	Eye Bolt	0.320Inches $\pm$ 0.010	0.330 0.310

Plex 12/8/17 11:31 AM dart.poulin.mario

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

